

Date: Thursday, 18/09/2008 11:41:19 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WINDOW		
Job Number	: 42120			Part Number	: D32903		
Estimate Number	: 11176			Drawing Number	: D3290 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/09/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : THERMOFORMING			Due Date	: 25/09/2008 Qty: 12 Um: Each		
Previous Run	: 39873						
Written By	:						
Checked & Approved By	:						
Comment	Est. A 04.08.18 New issue KJ/RF Est. B 06.05.09 Ecn 798 EC Est. C 07.05.29 Thermoform in-house DL Est. D 07.09.28 rev C dwg EC verified by: DD Est. E 07.11.28 Add -Hand finish deburring DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet m 10 9187
Comment: Qty.: 3.1500 sf(s)/Unit Total : 37.8000 sf(s) Polycast II or plexiglass G .125" 10876 1B 8-9-18		
2.0	WATER JET	FLOW WATER JET 1B 8-9-18
Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Dwg Rev: <u>E</u> 1B 8-9-18 Prog Rev: <u>E</u> (B)		
2-Deburr if necessary → SAD 08/09/129		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-9-18
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK S 08/09/18 (X/3)
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-3 PAR #: N/A Fault Category: Prod / FB. med & small NCR: Yes No DQA: D Date: 08/10/16

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 42120		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/16	20	two windows found with cutouts from water jet.	08/10/16	Build out PIRE to Thermalami	BB 08/10/08	S 08/10/08	J 08/10/16	S 08/10/16

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Without removing protective skin
remove sharp edge by degutting.

BB 08/10/07 X 13

6.0 THERMOFORMING

THERMOFORMING MACHINE



*See Pb on Previous Page

Comment: 1-THERMOFORM as per Drawing D3290 and Folio FTA001

Dwg. Rev. C
Folio Rev B

BB 08/10/08

X 13

2-Engrave part# & batch#,
(D3290-3)

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances

BB 08/10/08 X 13

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/10/08

9.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches if required

BB 08/10/08 X 13

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP 42121

10/10/08 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #: Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



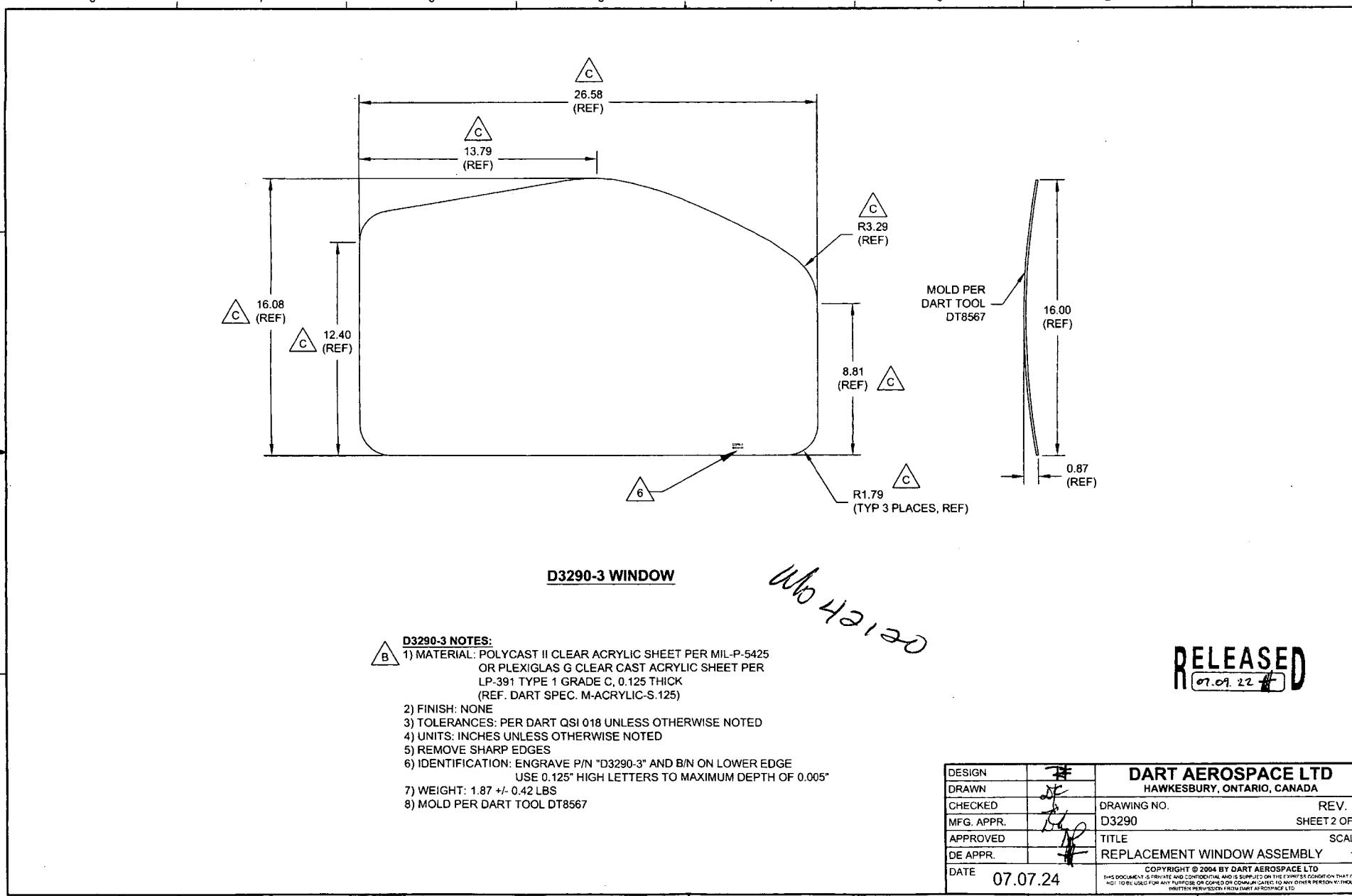
08/10/15 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-15



DART AEROSPACE LTD

Work Order: 42120

Description: Window

Part Number: 032903

Inspection Dwg: D3390-3, Rev: 6

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:

17

Audited by:

Prototype Approval:

1

Date

8-9-18

Date:

Date:

4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	